OWNER'S MANUAL

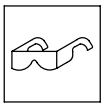
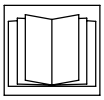
2010−04 FORM: OM-1046D (199753)

Flux Hopper With Valve 25 Lb

1. Specifications

Flux hopper
For automatic Submerged Arc (SAW) guns with flux flow control
Flux hopper capacity: 25 lb (11.3 kg)
Input power required for automatic valve: single-phase 115 volts AC, .5 amperes, 50/60 Hz
Flux hopper:: Height− 20 in. (508 mm), Width− 8-1/2 in. (216 mm), Length− 11 in. (279 mm) Weight− 11 lb (5 kg)

2. Safety Symbol Definitions

	DANGER! − Indicates a hazardous situation which, if not avoided, will result in death or serious injury. The possible hazards are shown in the adjoining symbols or explained in the text.		Beware of electric shock from wiring. Disconnect input power before installing this kit. Reinstall all panels and covers.
	Indicates a hazardous situation which, if not avoided, could result in death or serious injury**.** The possible hazards are shown in the adjoining symbols or explained in the text.		Wear safety glasses with side shields.
NOTICE 	*Indicates statements not related to personal injury.* *Indicates special instructions.*		Beware of moving parts.
	Recycle or dispose of used flux in an environmentally safe way.		Have only trained and qualified persons install, operate, or service this unit. Call your distributor if you do not understand the directions. For WELDING SAFETY and EMF information, read wire feeder and welding power source manuals.
	Beware of electric shock from the cutting torch or wiring. Touching the cutting torch while in contact with the work or ground can cause electric shock. Always wear dry gloves. Keep all panels and covers closed.		Hot flux and parts can cause burns. Welding makes flux and parts very hot − let them cool before touching.
	Cutting sparks can cause fire or explosion. Move flammables away. Do not cut on closed tanks or barrels − they can explode. Clean tanks or barrels properly.		Arc rays can burn eyes and skin − wear face protection (helmet or face shield) with correct shade of filter, and cover exposed skin with nonflammable clothing.
	Allow cooling period. Reduce current or reduce duty cycle before starting to cut again. Follow rated duty cycle.		Grinding causes flying pieces of metal and sparks. Wear a face shield.

Proposition 65 Warnings

Welding or cutting equipment produces fumes or gases which contain chemicals known to the State of California to cause birth defects and, in some cases, cancer. (California Health & Safety Code Section 25249.5 et seq.)

This product contains chemicals, including lead, known to the state of California to cause cancer, birth defects, or other reproductive harm. *Wash hands after use.*

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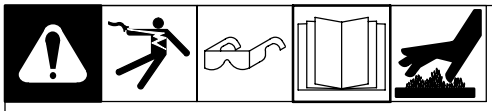
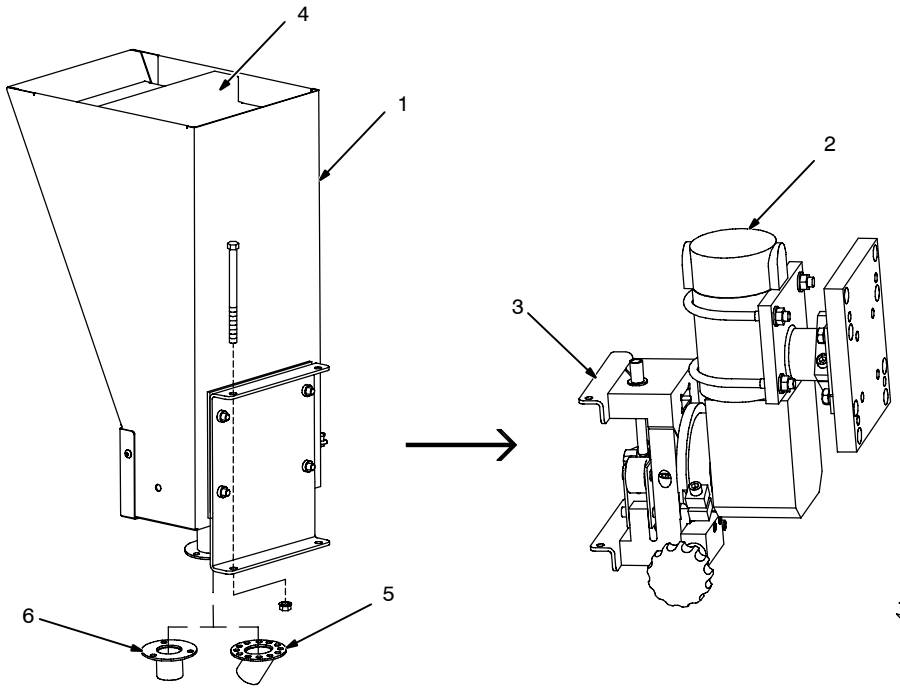
3. Flux Hopper Installation And Loading





1 Flux Hopper

2 Right Angle Drive Motor

3 Mounting Brackets

Mount flux hopper to right angle drive motor (not supplied) using mounting brackets and screws provided with right angle drive motor.

4 Lift-Out Screen

A lift-out screen is supplied to screen slag and large particles from used flux. Ensure that the flux valve is closed while loading. If a flux recovery system is installed on the hopper, open cover of recovery box to load or add flux.

5 30° Outlet For OBT-600 Torch

6 Straight Outlet For OBT-1200 Torch

Use proper outlet for torch.

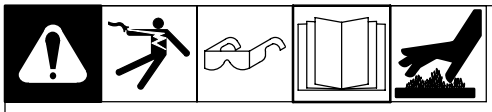
Tools Needed:

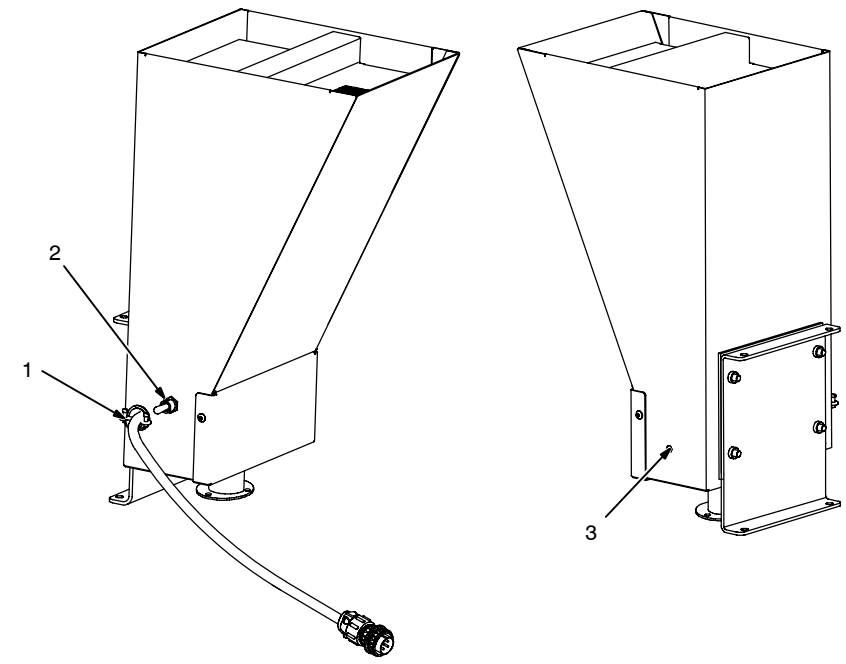
7/16 in.

1/8 in.

802 632

4. Flux Hopper Operation





Tools Needed: 9/64 in.

1 Control Cable

Connect control cable to 4-pin receptacle on HDC. If HDC does not have 4-pin receptacle, cut off connectors, strip back jacket and connect as follows:

Connect control cable to appropriate terminal strip on weld controller as follows:

Red wire (#31) to 115 VAC hot

White wire (#32) to 115 VAC neutral

Green wire (#33) to ground

Black wire (#52) to normally open pre-flux relay. The other side of this relay should be connected to 115 VAC hot.

☞ *If connecting to a MIller VL-M4 weld control, match the numbers on the control cable leads to the numbers on the VL-M4 terminal strip.*

2 Momentary Switch

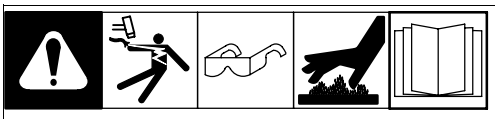
Press switch to manually release flux.

3 Adjustment Screw Access Hole

A screw is located inside the unit that allows the pressure of the pinch bar on the hose to be increased or decreased.

802 668-C / Ref. 802 632

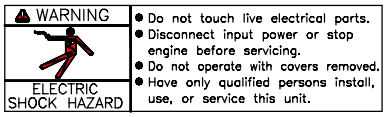
5. Routine Maintenance

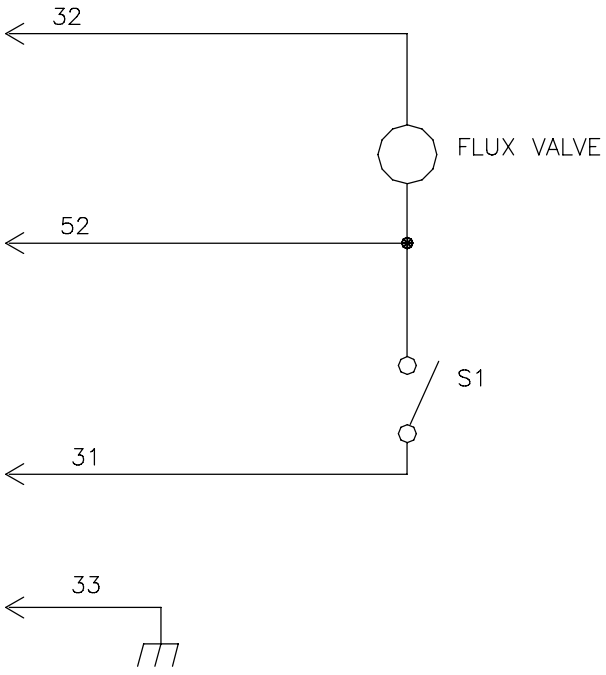


Disconnect power before maintaining.

Daily	Periodically (Depending On Usage)
Clean Flux Screen Check Flux Hoses For Damage Or Leaks	Check Condition Of Flux Outlet Tube For Cracks, Etc.
3 Months	
Replace Unreadable Labels	

6. Electrical Diagram


WARNING
ELECTRIC SHOCK HAZARD
Do not touch live electrical parts.
Disconnect input power or stop engine before servicing.
Do not operate with covers removed.
Have only qualified persons install, use, or service this unit.



200 155

7. Parts List

☞ *Hardware is common and not available unless listed.*

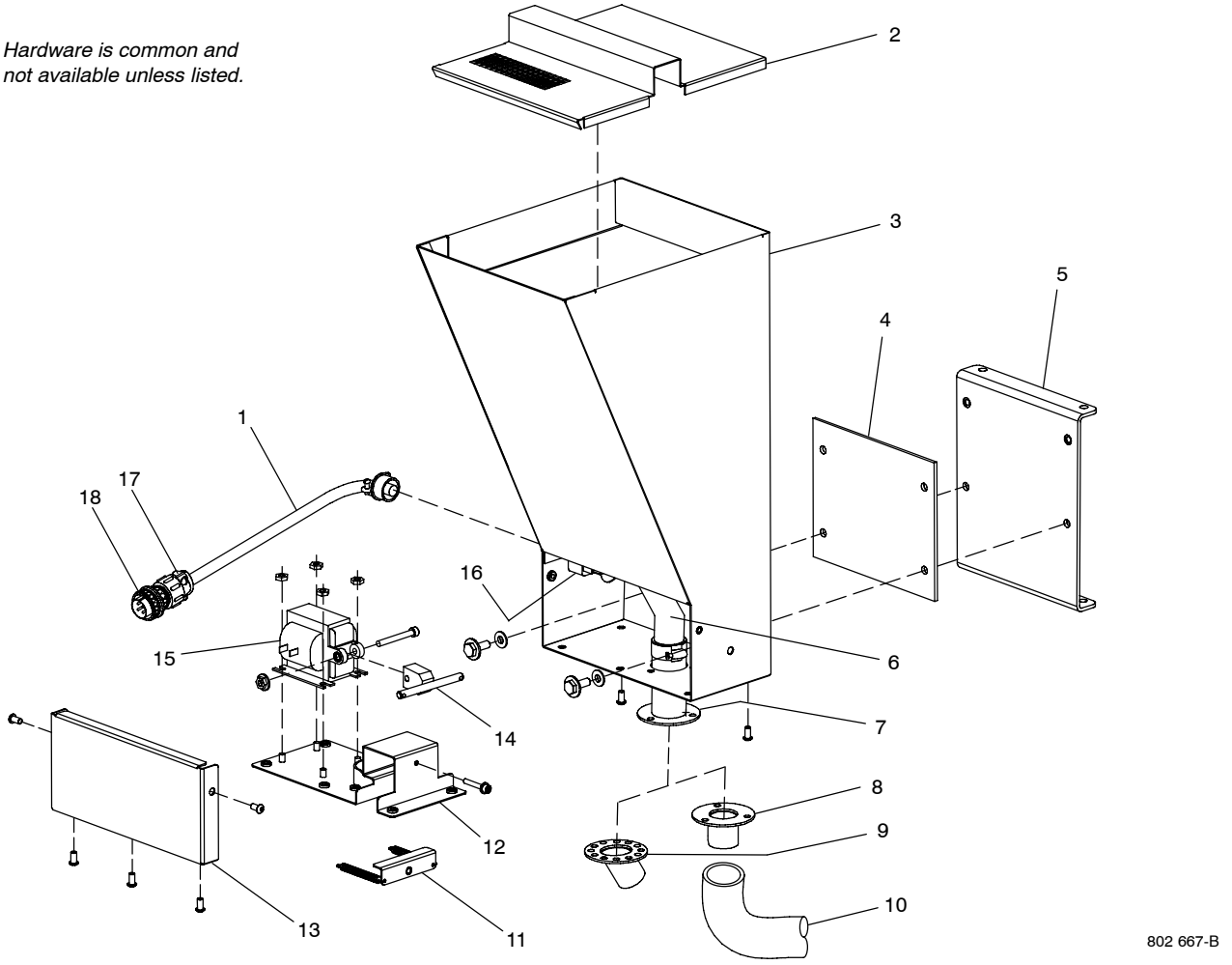


Figure 7-1. Flux Hopper

Item No.	Part No.	Description	Quantity

Figure 7-1. Flux Hopper

1	200 154	Control Cable, Automatic Flux Valve	1
2	199 878	Filter, Hopper	1
3	198 773	Reservoir, Flux Hopper	1
4	198 849	Insulator, Flux Hopper	1
5	198 772	Bracket, Mounting Flux Hopper	1
6	201 508	Tube, Flux Hopper	1
7	200 523	Adapter, Flux Outlet	1
8	199 880	Outlet, Hopper Straight	1
9	199 879	Outlet, Hopper 30 Degrees	1
10	200 439	Hose,1 In I.d. X 1/8 In Wall Flux Hopper	1
11	198 776	Bracket	1
12	198 775	Base, Flux Hopper	1
13	198 846	Door, Front Flux Hopper	1
14	228 705	Assy, Pinch Block Flux Hopper	1
15	198 847	Solenoid, 4 X 241	1
16	021 467	Switch, Momentary Toggle	1
17	200 546	Conn, Circ 97/Met Clamp Str Size 14S	1
18	239 080	Conn, Circ Ms/Met 4-Pin Size 14S Plug Cable Solder	1

+When ordering a component originally displaying a precautionary label, the label should also be ordered.

To maintain the factory original performance of your equipment, use only Manufacturer's Suggested Replacement Parts. Model and serial number required when ordering parts from your local distributor.